DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-023138
Date Inspected: 25-Apr-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 1900
OSM Departure Time: 700
Location: Shanghai, China

CWI Name:	See below			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☐ Yes	☑ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14
This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Zhu Lin, CWI Sun Tian Liang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG
PCMK: X3305K-033
Weld No: 001,002
Welder: 067876
WPS-B-T-2233-ESAB

Components; OBG
PCMK: X3305K-023
Weld No: 001,002
Welder: 045240
WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Zhu Lin, CWI Sun Tian Liang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG
PCMK: TR3021TR1-001
Weld No: 004
Welder: 066673, 066674
Repair No. B-WR20755
WPS-345-SMAW-2G(2F)-Repair-1

Components; OBG
PCMK: X3305K-015
Weld No: 001,002
Welder: 067611
WPS-B-P-2212-TC-U4b-FCM-1

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in OBW Splice Plate X4241D at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

This Caltrans QA Inspector observed at random intervals ZPMC performing grinding of welds located in OBW13 Splice Plate X3305K-017 at various locations due to contour grinding and visual indications as identified by ZPMC QC Inspectors.

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Xie Ming Feng, QA Zhang Qi Li .
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 E
PCMK: SEG3019AH
Weld No: 001
Welder: 216086
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: SEG3019*
Weld No: 017
Welder: 215553

WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14 E
PCMK: SEG3019E-1
Weld No: 025~048
Welder: 501946
WPS-B-P-2213-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Flux Core Arc Welding (FCAW) process.
ZPMC QC is identified as Xie Ming Feng, QA Zhang Qi Li.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 E
PCMK: SEG3019W
Weld No: 011,013
Welder: 067877
WPS-B-T-2233-ESAB

Components; OBG 14 E
PCMK: SEG3019V
Weld No: 227
Welder: 058102, 044772
Weld Repair No. B-WR20407
WPS-345-FCAW-3G(3F)-FCM-Repair-1

Components; OBG 14 E
PCMK: SEG3019S
Weld No: 342,350,343,345,351
Welder: 058102, 044772
Weld Repair No. B-WR20407
WPS-345-FCAW-3G(3F)-FCM-Repair-1

Components; OBG 14 E
PCMK: SEG3019Q-2
Weld No: 205,207,214
Welder: 058102, 044772
Weld Repair No. B-WR20407
WPS-345-FCAW-3G(3F)-FCM-Repair-1

Components; OBG 14 E
PCMK: SEG3019N
Weld No: 266,172,295,273

Welder: 058102, 044772
Weld Repair No. B-WR20407
WPS-345-FCAW-3G(3F)-FCM-Repair-1

Components; OBG 14 E
PCMK: SEG3019L
Weld No: 219,221
Welder: 058102, 044772
Weld Repair No. B-WR20407
WPS-345-FCAW-3G(3F)-FCM-Repair-1

Heat straightening of OBG14 East Bottom Plate at Panel Point 125 under approved Heat Straightening procedure, HSR1 (B)-465. The in process temperature was observed as 450°C. The ZPMC QC was identified as Xie Ming Feng. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 numbers of applications was allowed. The distortion that was previously measured and recorded on the HSR was Maximum 8mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:
"No relevant conversations."
Comments
This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer